August 14, 2009 7:48:02 AM

Item ID:

D2282-041

Accept



Setup Start



E **Revision ID:**

Item Name: T Assembly

08/14/2009 **Start Oty: 29.00**

Req'd Qty: 29.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Required Date: 08/19/2009

Process Plan: WF

Date: 09-108-14 Tooling:

Date: ___

Start Run



Revision Nbr

Date: SPC (Y/N):

Date:

Stop

Stop

Sequence ID/. Work Center ID Operation Description Set Up/ Run Hours

Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Number

Stamp

D2282

Rev E

100

Draw Nbr

Large Fab

Memo

0.00

0.00

Large Fab Large Fab

1-Weld as per D2282-041 'T' Handle Assembly□ Grind chamfers and ensure full penetration as per dwg D2282 = ****** brush weld right after welding, to Filling Rod HIOZ-HILL. take color off ****** DA/RER316L SS

09.08.17.

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

09.08-19

120

Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

0.00

B 9-8-17

W/O:		2000	WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Category: NCR: Yes No DQA: [
Resolution:			Disposition	າ:	QA: N/C C	losed:		Date:			
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	₹)			. ,		
DATE	STEP	Description of NC		ection B Verific			Approval	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector		
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1710.7											
		1			1			I	J .		

Work Order ID 51288

Page 2

August 14, 2009 7:48:02 AM

Required Date: 08/19/2009

Item ID:

D2282-041

Accept

Setup Start

Revision ID: Ε

Item Name:

T Assembly

Start Qty: 29.00 08/14/2009

Req'd Qty: 29.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan: _____

Date:

Tooling:

Date:

Run Start

Reject

Qty



Date:_____

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan

Code

Stop

Stop

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Number

Draw

Accept

Qty

Reject Insp. Number Stamp

140

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

150

Memo

0968/2678

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			·							
Part No	<u> </u>	PAR #:	Fault Cate	egory:	NCR:	Yes N	lo DQ	<u> </u> A:	Date:	
						WC Closed: Date:				
NCR:	:		WORK ORD	ER NON-CONFORMA	NCE (I	NCR))	•		
DATE	STEP	Description of NC	, , , , , , , , , , , , , , , , , , , ,					Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Verific Secti		Chief Eng	QC Inspector
•										
									• .	
							1			
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August 14, 2009 7:48:01 AM

Work Order ID: 51288

Parent Item:

D2282-041RevE

Parent Item Name: T Assembly

Comments:



Start Date: 08/14/2009

Required Date: 08/19/2009

Start Qty: 29.00

Required Qty: 29.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2282-3RevE	ILKIA ILKE KI BURENA IKI IRA	Manufactured	No			100	Each	29.0000	29.0000			

Manufactured

No

Warehouse Loc Oty Loc Code Location Main Warehouse ST 29

Each

Loc Qty

48279 29

100

63.0000 29.0000

Loc Code

D2282-5RevE
- 1,200,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 100,000 10

Tube

Warehouse Location Main Warehouse ST

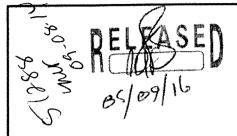
63 46429 18 48281 45

18. Sporo8.14.

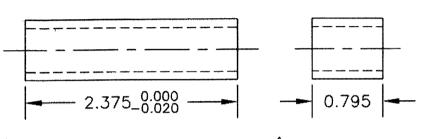
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W/O:			W	ORK ORDER CHANG	GES	·				
DATE	STEP	PROCEDURE CHANGE				,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
VII										
		PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:					
Resolution:			Dispositi	on:	QA: N/0	Clos	ed:	•	Date: _	
NCR:			WORK ORD	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC		ction B	Sign & Section				Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		ate	Section	on C	Chief Eng	QC Inspector
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					1					



DESIG	N BW	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
CHECK	KED . O	APPROVED_	DRAWING NO.	REV. E
	W	1000	D2282 sH	EET 1 OF 2
DATE			TITLE	SCALE
05.0	6.07		HANDLE TUBES	1:1
А		94.10.14	NEW ISSUE	
В		95.03.23	RE-DESIGN	
С		97.10.20	CORRECTED NUMBERING SCHEME	
		AC A7 4 A	DEDECION DOCCO E 0.705 WAC	0.750

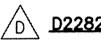


Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



Ø0.675 (REF) Ø0.493 (REF)

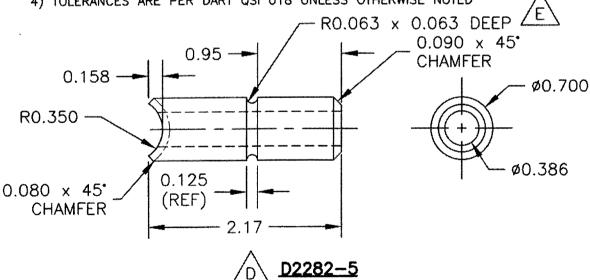
D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

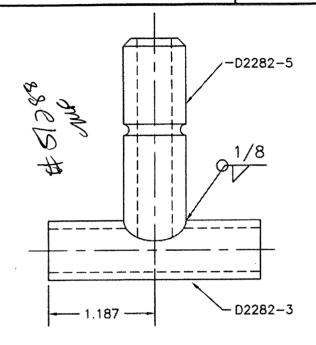
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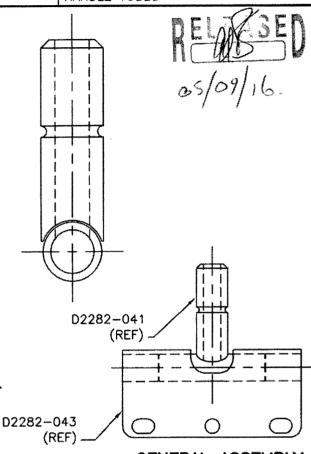
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W/O:		· · · · · · · · · · · · · · · · · · ·	WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No: PAR #: _		PAR #:	Fault Cate	gory:	NC	NCR: Yes No DQA:				Date:		
Resolution:			Disposition	າ:	QA	: N/C Clo	sed:		Date:	-		
NCR:		,	WORK ORDE	R NON-CONFO	PRMANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action Section E Initial Action Description			0:	Verific	ation		Approval		
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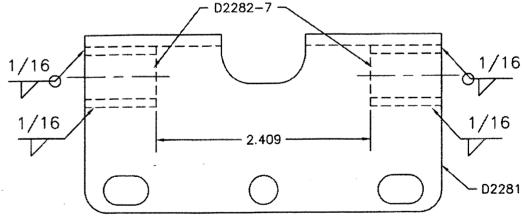
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CHECKED	APPROVED	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE		me	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-041 'T' ASSEMBLY WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY SCALE 1:2



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

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		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition	on:	QA	: N/C CI	osed:		Date: _	 	
NCR:			WORK ORD	ER NON-CONFOR	MANCE	(NCF	R)		-		
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval	
-/		Section A	Initial Chief Eng	Action Descriptio		Sign & Date	Secti	on C	Chief Eng	QC Inspector	
		•								!	
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